

535

DART AEROSPACE LTD	Work Order:	23940
Description: Saddle billet	Part Number:	D6101-005
Drawing: D6101 Rev. A	Qty:	180

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Open W/O	AL	05/28/04	100
2	PURCHASING	Issue P/O: 2008446 2008787 a) Description: Alluminum billet b) 5.00" x 8.250" x 2.50" thick c) Tolerance on all dimensions are +0.030"/-0.000" d) Grain direction along 5.00" length e) Material: 7075-T7351 (QQ-A-250/12) Material certification required	AL	05/19/07	100
3	RECEIVING	Receive & Inspect for transit damage Ensure certification are attached	CL	06/02/06	100
4	QC	Inspect level 6 Check certification to Dwg D6101 for compliance	ML	06/02/15	100
5	STORES	Identify & stock	CL	06/02/07	100
6	EXPEDITING	Close W/O Cost / part <u>5.45</u> 06/02/16 <u>Inspect Level 21</u>	CL	06/02/16	100

Rev	Date	Change	Revised By	Approved
A	01.05.04	New Issue	EC	EC

RELEASED

EC 01.05.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LS Date: 06/02/16

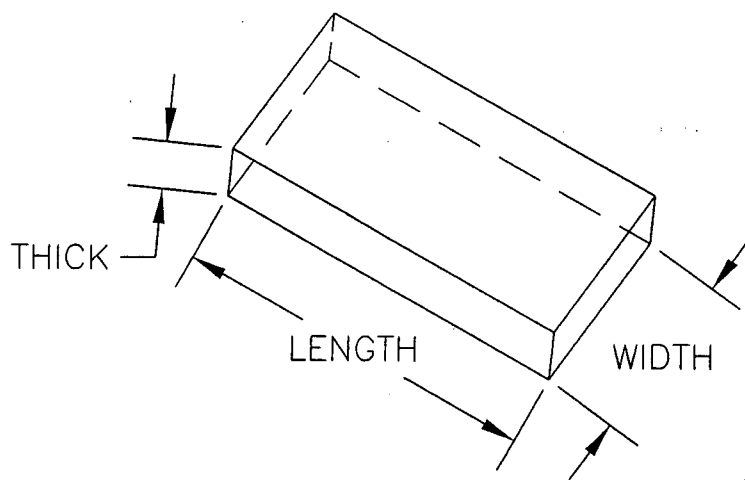
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>JS</i>	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



RELEASED
01.04.23 *CP*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 23940

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 03, 2005
02:45 pm

Work Order No	: 0023940	Department Code:	
Project Name	: D6101-005	Burden Flags	: NNNNNNN
Project For	: WK535	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D6101-005	Invoice Number	:
Description	: 7075-T7351 8.25X5.0X2.5	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 507.00	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 08-03-05		
Est Finish Date	: 08-31-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.
Per:

Mark J. Vrabec

Mark J. Vrabec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

573890	19028		
<u>Ship Date</u>	<u>B.L. No.</u>	<u>Invoice No.</u>	<u>Alcoa No. Item</u>
2006-01-20	02084	54800	DS-91531-1
<u>P.O. No./Govt Contract No.</u>	<u>Customer</u>		
CH1889	C&B-WALLINGFORD		

Page 1

Ship To: COPPER & BRASS SALES INC
WALLINGFORD BRANCH
5 STERLING DRIVE
WALLINGFORD, CT 06492

Item Description
2.500 IN TK X 60.5 IN W X 157.5 IN LN (N) A/T 7075-
T7351 RECTANGLE MILL FINISH, USI 3MM DEAD ZONE REQ'D BOTH SIDES,
SAWED {{ P/N 091557-9. }}. PER AMS-QQ-A-250/12 & EXCEPT MARKING AMS-
STD-2154 & EXCEPT MARKING MMS159 REV N &
EXCEPT MARKING ASTMB209 REV 04 & EXCEPT
MARKING BSS7055 REV A & EXCEPT MARKING
AMS4078 REV F USI PER PS21211 REV J MARKING PER
PS16120 REV G ULTRASONIC INSPECTION PE
ASTMB594 REV 02 ((MARKED)) INTERLEAVED MAX
GROSS SKID WGT: 5000 LB QUAN TOL +/-30 %
USI CL A 3 MM CQR 0162473 REV 01 CUST REQ 06-01-
01 *** W/E 06-01-07 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	367454	611671	2433	1	PC	
2	367470	611671	2424	1	PC	
3	367471	611671	2410	1	PC	
4	367484	611671	2432	1	PC	
			9699	4		

Notes for CQR: 0162473.1

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/12 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/12F. PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/12F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/12. PRODUCT PRODUCED TO THE REQUIREMENTS OF MIL-STD-2154 ALSO MEET THE REQUIREMENTS OF AMS-STD-2154. PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS-STD-2154 ALSO MEET THE REQUIREMENTS OF MIL-STD-2154. THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMMERSION - TYPE I.

CQR: 0162473.1 -Specification Limits -----

		UTS	TYS	EL4D
Temp	Dir	KSI	KSI	PCT
T7351	Long Transv.	Max	63.9	
		Min	66.0 52.0	6
T7351	Elec. Cond. (EC)	% MIN	38.0	PCT

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA

DAVENPORT WORKS

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Per:

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573890

Ship Date

2006-01-20

P.O. No./Govt Contract No.

CH1889

19028

B.L. No.

02084

Invoice No.

54800

Customer

C&B-WALLINGFORD

Ship From: RIVERDALE, IA.

Alcoa No. Item

DS-91531-1

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CQR: 0162473.1 -Specification Limits (cont.)

Chemical Composition		SI	FE	CU	MN	MG	CR	ZN	TI	Other	
										Each	Total Aluminum
Alloy 7075	Max	.40	.50	2.0	.30	2.9	.28	6.1	.20	.05	.15
	Min			1.2		2.1	.18	5.1			REMAIN

Lot: 611671 -Mechanical, Physical, Metallography, Quantometer Results

Tmpr	Dir	No.	Test	UTS	TYS	EL4D
T7351	Long Transv.	3	Max	71.3	60.1	10.6
			Min	70.9	59.8	10.5
T7351	Elect Cond	%IACS	40.0	40.1	40.2	PCT

Cast Number	Chemical	SI	FE	CU	MN	MG	CR	ZN	TI
H9295041	Actuals	.07	.28	1.6	.03	2.5	.19	5.6	.02